



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3310
Job Sheet 186253



DAS
21
9-89

Part No: 646.3310

Job Qty: 20 ea

Part Name: LH Half - Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/28/18	11/28/18	0.00	0.00	Start Up Machining-1		DAS 18/12/18
110	CNC Vertical Machining	20 pcs	11/28/18	11/28/18	0.44	26.32	HAAS1-1		52 18/12/18
120	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC2 Machining-1		9-89 18/12/18
130	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC8 Machining-1		18/12/18
140	Outsource	20 pcs	11/28/18	11/28/18			ATG001-VC	10	18/12/18
150	Packaging	20 pcs	11/28/18	11/28/18	0.00	0.00	Packaging2		18/12/18
155	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC5		61 18/12/18
180	Packaging	20 pcs	11/28/18	11/28/18	0.00	0.00	Packaging3-1		9-89 18/12/18
190	QC21-SA	20 Ea	11/28/18	11/28/18	0.00	0.00	QC21		9-89 18/12/18

Part Op 110 - 1-Machine per folio FB154 Blank 13.375

Descriptions: 140 - Issue P/O to ATG : P00-11947 1- Black Anodize as per Dwg 646.3300

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X7.000	7075-T6S Sheet 2" Thick Plate X 7" Wide (Order In Billets - 13.375")	22.2800 ft (1.114 ea)	90-Start up Operation	S090188x12 S043347x1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S2.000X7.000	22	26	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	LH Half	7.296inches $\pm$ 0.005	7.301 7.291	7.296	
2	LH Half	3.767inches $\pm$ 0.005	3.772 3.762	3.767	
3	LH Half	0.457inches $\pm$ 0.005	0.462 0.452	0.457	
4	LH Half	0.313inches $\pm$ 0.005	0.318 0.308	0.313	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY Power Loss/Surge ☐ Program ☐ n ☐ d ☐ ng Stock Pulled ☐ of Sequence ☐ et ☐ beled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
Process Improvement ☐ Marks/Chatter ☐ Drill Holes ☐					
Manufacturing Process ☐ Past Due ☐ OTHER : _____					

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S134293



Part: 646.3310
 Job No: 186253
 Serial No/Batch: S134293

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 12/04/18

5	LH Half	0.710inches $\pm$ 0.005	0.715 0.705	0.710	
6	LH Half	6.469inches $\pm$ 0.005	6.474 6.464	6.469	
7	LH Half	10.116inches $\pm$ 0.005	10.121 10.111	10.116	
8	LH Half	10.309inches $\pm$ 0.005	10.314 10.304	10.309	
9	LH Half	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	0.178	Diameter
10	LH Half	0.209inches $\pm$ 0.005 - 0.001	0.214 0.208	0.210	Diameter
11	LH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.250	
12	LH Half	1.250inches $\pm$ 0.005	1.255 1.245	1.250	
13	LH Half	0.125inches $\pm$ 0.005	0.130 0.120	0.125	Radius
14	LH Half	3.513inches $\pm$ 0.005	3.518 3.508	3.513	
15	LH Half	8.375inches $\pm$ 0.005	8.380 8.370	8.375	
16	LH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.253	
17	LH Half	8.100Degrees $\pm$ 0.500	8.600 7.600	8.100°	Angle
18	LH Half	11.689inches $\pm$ 0.005	11.694 11.684	11.689	
19	LH Half	11.250inches $\pm$ 0.005	11.255 11.245	11.250	
20	LH Half	0.200inches $\pm$ 0.005	0.205 0.195	0.200	
21	LH Half	45.000Degrees $\pm$ 0.000	45.000 45.000	45°	Angle

DIP 18-12-01

Plex 11/13/18 10:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
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PURCHASE ORDER **PO041947**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041947
PO Date: 12/5/18
Due Date: 12/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Attention: Lalande, Marc-Andre

Via: Ground
Pynt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184104	RBH9928-12-5	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/7/18	12 pcs	0 pcs	12 pcs	\$4.99/pcs	\$59.88
2	R185822	RBT400214-1	Frame Weld Mount -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/12/18	2 pcs	0 pcs	2 pcs	\$4.99/pcs	\$9.98

Line Item Note ** Friday, please? :(**



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PURCHASE ORDER **PO041947**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185605	D5585-1	Stringer, LH Fwd : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5585 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/7/18	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00
Line Item Note ** Can we have ASAP, Friday? **											
4	185606	D5586-1	Stringer, RH Fwd : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5586 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/7/18	9 pcs	0 pcs	9 pcs	\$7.50/pcs	\$67.50
Line Item Note ** Can we have ASAP, Friday? **											
5	185607	D5587-1	Stringer, LH Aft : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5587 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/7/18	11 pcs	0 pcs	11 pcs	\$7.50/pcs	\$82.50
Line Item Note ** Can we have ASAP, Friday? **											



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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	185608	D5588-1	Stringer, RH Aft : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5588 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/7/18	9 pcs	0 pcs	9 pcs	\$7.50/pcs	\$67.50
Line Item Note ** Can we have ASAP, Friday? ** 9 X DEC 07 2018											
7	185609	D5589-1	Gusset, Outboard LH : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5589 2- Prime Grey as per Dwg. QSI 005,4.2.1.3.2 Certification of Conformity is required.	Firmed	-	12/7/18	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00
Line Item Note ** Can we have ASAP, Friday? ** 10 X DEC 07 2018											
8	185610	D5589-2	Gusset, Outboard RH : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5589 2- Prime Grey as per Dwg. QSI005 4.2.1.3.2 Certification of Conformity is required.	Firmed	-	12/7/18	8 pcs	0 pcs	8 pcs	\$7.50/pcs	\$60.00
Line Item Note ** Can we have ASAP, Friday? ** 8 X DEC 07 2018											
Line Item Note ** Can we have ASAP, Friday? **											



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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	185242	RBE105-14181W2-1	Guide -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/12/18	5 pcs	0 pcs	5 pcs	\$4.99/pcs	\$24.95
						5 X DEC 07 2018					
10	186948	647.4114	Shim Issue P/O ATG, black anodize and prime as per dwg 647.4114 Rev. N/C	Firmed	-	12/17/18	10 pcs	0 pcs	10 pcs	\$7.40/pcs	\$74.00
11	186253	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed	-	12/17/18	13 pcs	0 pcs	13 pcs	\$19.25/pcs	\$250.25
						13 X DEC 18 2018					
12	180996	RB877206-5-3	Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	12/27/18	8 pcs	0 pcs	8 pcs	\$4.99/pcs	\$39.92
						8 X DEC 18 2018					
13	184952	RBW6405G00332-3G-9	Knob -Issue P/O to ATG PO: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	-	12/17/18	8 pcs	0 pcs	8 pcs	\$4.99/pcs	\$39.92
						8 X DEC 07 2018					



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PURCHASE ORDER **PO041947**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
14	184949	RBW6405G00332-3G-3	Round Seat -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/17/18	4 pcs	0 pcs	4 pcs	\$4.99/pcs	\$19.96
15	186503	D5590-2	Gusset, Inboard RH : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5590 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/20/18	6 pcs	0 pcs	6 pcs	\$7.50/pcs	\$45.00
16	186502	D5590-1	Gusset, Inboard LH : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5590 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/27/18	6 pcs	0 pcs	6 pcs	\$7.50/pcs	\$45.00

Grand Total: \$1,036.36



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PURCHASE ORDER
PO041947

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/7/18 10:32 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916825

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
18 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24286	Rev: A PO: PO041947 Line: 11	186253
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>12/17/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

